

Date: Thursday, 3/23/2006 3:44:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CAP
 Job Number : 26351
 Estimate Number : 10519
 P.O. Number : NIA Part Number : D2855
 This Issue : 3/23/2006 S.O. No. : NIA Drawing Number : D2855 REV. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 23925 Material : NIA
 Written By : SEE COMMENTS BELOW Due Date : 4/10/2006 Qty: 25 Um: Each
 Checked & Approved By : JF 06.03.24
 Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 00000887

Cast per Dwg D2855

Material Release Note Required

2.0 D2855P Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)
 CAP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 04/04/25

(100)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06/06/25

(100)

Comment: INSPECT POWDER COAT

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M100489

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

DL 04/04/25

(100)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

DL 04/04/25

(100)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

DL 06/06/26 (100)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 06/06/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/06/27 (100)

Job Completion



6 0606-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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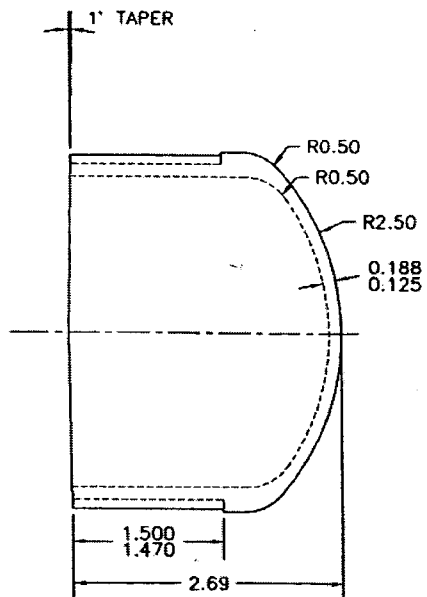
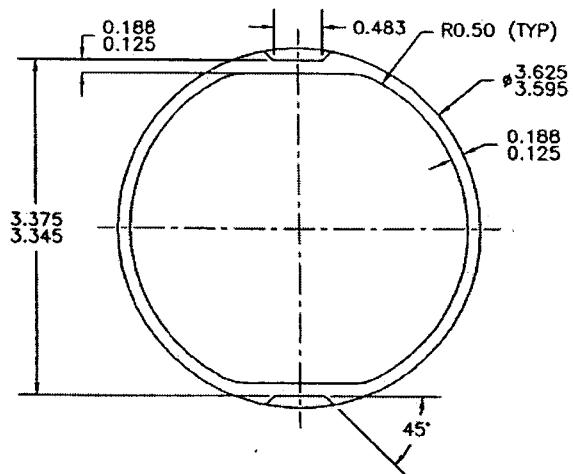
NOTE: Date & initial all entries



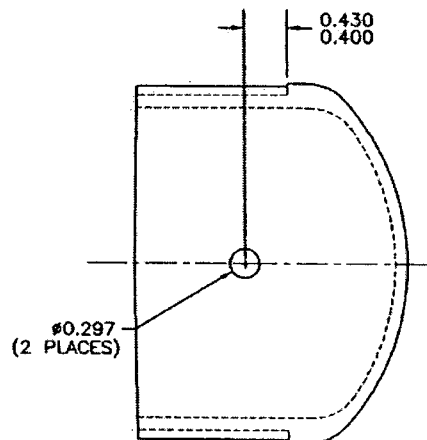
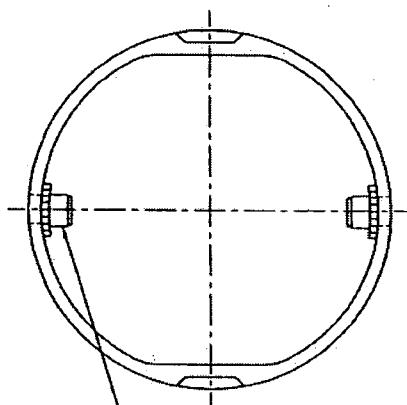
DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		TITLE	SHEET 1 OF 1
98.12.12		CAP	SCALE NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

RELEASED
98.12.14 D5

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26351

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Date: **21/04/2006** Packing Slip No. **5482**

Hawksbury, ON, K6A 1K7

Votre No. Commande **887** P.O.
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
100	DRWG D 2855 rev A	Z098046	A356.2 	B#0610801 ingot #814303

Analyse
Analysis (as in ingot)

(Si)	7.2%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.44%		
(Zn)	<0.01%		
(Ti)	0.11%		

Donne
Yield :

Résistance a la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100